

Date: Tuesday, 31/03/2009 1:03:36 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET BASE ASSEMBLY (350)
Job Number : 46730A	
Estimate Number : 10189	
P.O. Number :	Part Number : D2221
This Issue : 31/03/2009 S.O. No. :	Drawing Number : D2221 REV H
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : H
Previous Run : 46666A	Material :
Written By :	Due Date : 08/04/2009 Qty: 1 Um: Each

Checked & Approved By : JLD 09.03.31
Comment : Est Rev:J 05.09.02 Added D3442-1 KJ/JLM
 Est Rev:K 08-08-29 revG as per dwg DD verified by:EC
 Est Rev:L 08-09-24 plug holes prior to powder coat DD
 verified by:EC
 Est Rev:M 08-12-02 revH as per dwg DD verified by:

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22211	Rib
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib

batch: B46388 → 1_xSL 09/03/31

2.0	D22215	Rib
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib

batch: B46365 → 2_xSL 09/03/31

3.0	D22217	Rib
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib

batch: B46366 → 1_xSL 09/03/31

4.0	D22323	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

batch: B46626 → 2_xSL 09/03/31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 46730A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22351

Basket Rib



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Basket Rib

batch: B46627 → 2x

SM 09/03/31

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Mounting Bracket

batch: B45684 → 2x

SM 09/03/31

7.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Shim

* batch: B46464 → 1x B46767 → 1x

SM 09/03/31

8.0

D3825041

Rib Assembly (Basket End)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rib Assembly (Basket End)

batch: B46390 → 2x

SM 09/03/31

9.0

D3826041

Rib / Gusset Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rib / Gusset Assembly

batch: B46723 → 2x

SM 09/03/31

10.0

D3827041

Rib Assembly (Inboard)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Rib Assembly (Inboard)

batch: B46090 → 1x

SM 09/03/31

11.0

D38331

Mesh (Base End Face)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Mesh (Base End Face)

batch: B46665 → 2x

SM 09/04/02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 46730A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D38321

Mesh (Base)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Mesh (Base)

batch:

B46306 → L

SY 09/04/02

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221

3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: M108715 H

SY 09/04/02

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.04.07

15.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09.04.07 (1)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

m110939

1- Plug holes prior to powder coating

2-Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

11:15

OVEN TEMPERATURE:

400°

FINISH TIME:

11:45

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

12:50

OVEN TEMPERATURE:

400°

FINISH TIME:

1:20

FL 09/04/08 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46730A

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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-13 (X1)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14 J

Job Completion



110 96 730

09/04/14 C

U. G. A. L. Y

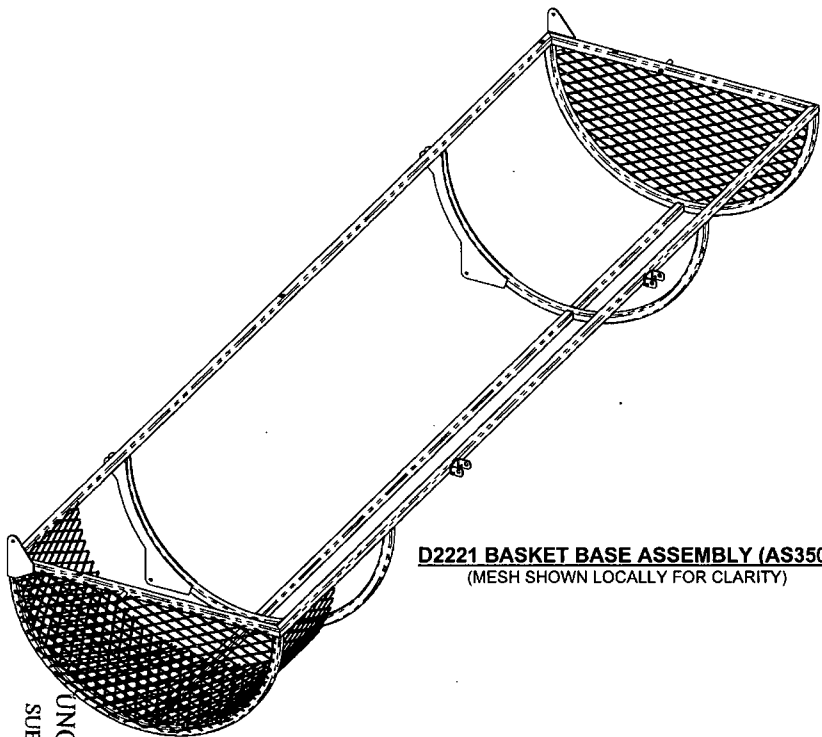
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

H

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

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NO. 467301

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: 42.00 lbs APPROX
 - 9) MASK ALL HOLES PRIOR TO POWDER COATING

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JS	
CHECKED	JS	DRAWING NO. D2221
MFG. APPR.	JS	REV. H
APPROVED	JS	SHEET 1 OF 5
DE APPR.	JS	TITLE SCALE
DATE	08.09.18	BASKET BASE ASSEMBLY (350) NTS

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8

7

6

5

4

3

2

1

D

C

B

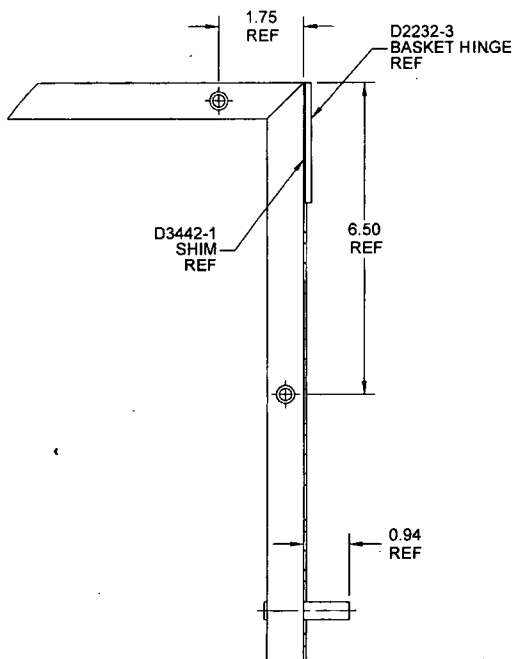
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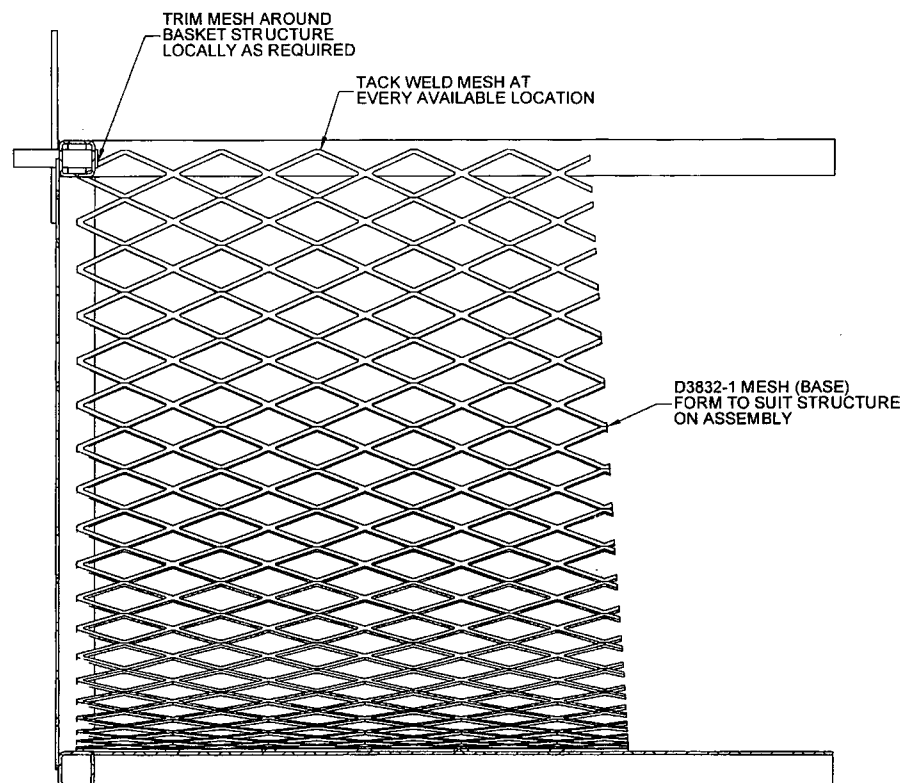
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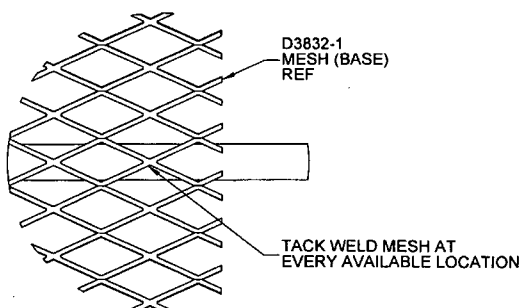
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DETAIL D
SCALE 4X D2-2



SECTION F-F
SCALE 4X D7-2



DETAIL E
SCALE 4X C6-2

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DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. H
CHECKED		D2221	SHEET 4 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET BASE ASSEMBLY (350)	NTS
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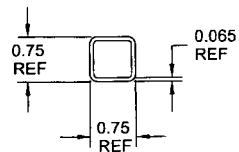
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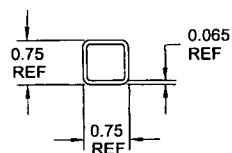
1



D2221-1 RIB

96.00

0.75 X 45° CHAMFER
2 PL



D2221-5/-7 RIB

D2221-5: 18.85
D2221-7: 55.25

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	MS	D2221	SHEET 5 OF 5
APPROVED	MA	TITLE	SCALE
DE APPR.	CH	BASKET BASE ASSEMBLY (350) NTS	
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